

Date: Tuesday, 02/12/2008 11:17:02 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : LUG BRACKET
<b>Job Number</b> : 43885B	
<b>Estimate Number</b> : 10339	
<b>P.O. Number</b> :	<b>Part Number</b> : D2658
<b>This Issue</b> : 02/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2658 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 35600B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/12/2008 <b>Qty:</b> 14 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.12.02</u>	
<b>Comment</b> : Est Rev:A New Issue 05-11-07 JLM	
Est Rev:B Now on Waterjet 06-08-23 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S12GA	1010/102 mild steel sheet 12ga
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**Comment:** Qty.: 0.1197 sf(s)/Unit Total: 1.6758 sf(s)  
 1010/1025/A21/6aA SHEET  
 12 GAUGE .100" THK  
 Batch: 104288 1B 8-12-11

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2858  
 Dwg Rev: D 1B 8-12-11  
 Prog Rev: D



2-Debur if necessary 1B 8-12-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

505/12/11



counter

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Debur as required. 5

2-Bend on CNC brake using DT8254 Identify as D2658

505/12/11



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: LUG BRACKET

Job Number: 43885B

Part Number: D2658

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Locality*  
*506/12/16* *(X20)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W/A*

*FL 8-12-16* *X20*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/12/17* *df*

Job Completion



*mt 08-12-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

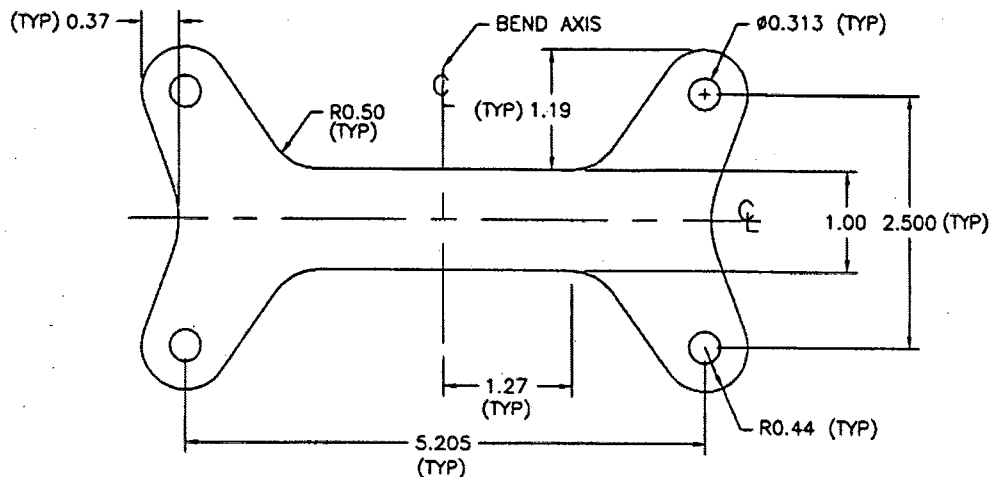


**DART**

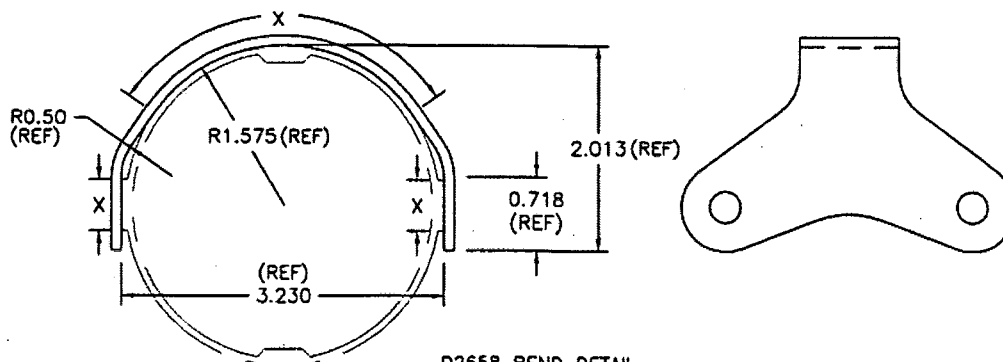


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2658	REV. D SHEET 1 OF 1
DATE 98.12.14		TITLE LUG BRACKET	SCALE 5:9
A	97.11.03	NEW ISSUE	
B	97.12.18	5.205 WAS 5.015, ADD TOOLING HOLE	
C	98.10.23	UPDATE MATERIAL (TSR A1114)	
D	98.12.14	REMOVE TOOLING HOLE (TSR A1040)	

**RELEASED**  
98.12.14 DS



**D2658 FLAT PATTERN**  
SYMMETRICAL ABOUT BOTH CENTRE-LINES (CL)



D2658 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

**GENERAL NOTES**

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
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